

Date: Wednesday, 17/09/2008 10:40:19 AM
 User: Jean-Luc Menard

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : HINGE
Job Number : 42053	
Estimate Number : 13558	
P.O. Number :	Part Number : D38133
This Issue : 17/09/2008 S.O. No. :	Drawing Number : D3813 PREL <i>prfo</i>
Prsht Rev. : NC	Project Number : N/A
First Issue : / /	Drawing Revision : PREL
Previous Run :	Material :
Written By : <i>JLM 08.09.17</i>	Due Date : 24/09/2008 Qty: 3 Um: Each
Checked & Approved By :	
Comment : Est Rev: A New Issue 08-09-03 JLM Verified By: EC	

Additional Product

PRELIMINARY ISSUE

Job Number:

**PRELIMINARY ISSUE**

Seq. #: Machine Or Operation: Description :

1.0 M6061T6B0750X03000 6061-T6 Bar .750 x 3.00



Comment: Qty.: 0.5040 f(s)/Unit Total : 1.5120 f(s)
 6061-T6 Bar .750 x 3.00
 BATCH: *M104741*

J.L 08/09/21

2.0 BAND SAW BAND SAW



Comment: BAND SAW
 Cut blank 5.725 " long

J.L 08/09/21

3.0 HAAS1 HAAS CNC VERTICAL MACHINING #1



Comment: HAAS CNC VERTICAL MACHINING #1

1- Mill as per Folio FA778 Rev. *A* & Dwg D3813 Rev. *A*

2-Deburr per dwg D3813

3-Finish tapping hole to final depth as per Dwg D3813

DJP J.L 08/09/22

4.0 QC2 INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

DJP J.L 08/09/22

5.0 QC8 SECOND CHECK



Comment: SECOND CHECK

mx 08/09/24

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: HINGE

Job Number: 42053

Part Number: D38133

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

410

08-10-02 (X4)

7.0

POWDER COATING

POWDER COATING



M 109152



(4X)

Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

MASK THREADED HOLE PRIOR TO POWDER COAT

START TIME:

OVEN TEMPERATURE:

FINISH TIME:

8-10
8-320 OF
8-40

M-1 08/10/03

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

08-10-03

(XC)

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

for Dac2 D3813-041

18 08/10/03 (X4)

10.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



POSITIVE RECALL

EFFECTIVE DATE

RELEASED DATE

AUTH

DATE

11 08/10/03

NA

DART AÉROSPACE LTD		Work Order: 42053
Description: hinge		Part Number: D3813-3
Inspection Dwg: D3813 , Rev: A		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST


☒ First Article ☒ Prototype

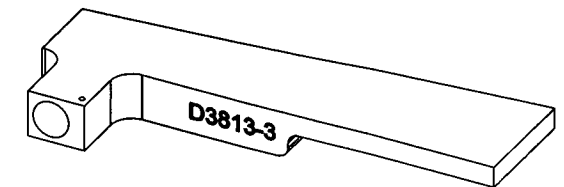
Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
.56	$\pm .030$.565	✓			
.28	$\pm .030$.28	✓			
.56	$\pm .030$.561	✓			
.281	$\pm .010$.281	✓			
Ø.391	$\pm .006$ $- .001$.391	✓			
1.25 deep	$\pm .030$	1.240	✓			
1.13	$\pm .030$.130	✓			
2.50	$\pm .030$	2.500	✓			
.25	$\pm .030$.255	✓			
5.50	$\pm .030$	5.503	✓			
.69	$\pm .030$.690	✓			
.28	$\pm .030$.280	✓			
.13	$\pm .030$.120	✓			
.87	$\pm .030$.873	✓			
.93	$\pm .030$.925	✓			
85°	$\pm 1/2^\circ$	85°	✓			
1.40	$\pm .030$	1.398	✓			
1.25	1.28 $\pm .030$	1.25	✓			
.06	$\pm .004$ $- .001$.062	✓			
.09	$\pm .030$.090	✓			

Measured by: 51	Audited by: <i>[Signature]</i>	Prototype Approval:
Date: 08/09/22	Date: 08/09/24	Date:

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	

NOTES:

- | | | | |
|---------------|---|--|--------------|
| DESIGN |  | DART AEROSPACE LTD | |
| DRAWN | | HAWKESBURY, ONTARIO, CANADA | |
| CHECKED | | DRAWING NO. | REV. A |
| MFG. APPR. | | D3813 | SHEET 4 OF 4 |
| APPROVED | | TITLE | SCALE |
| DE APPR. | | HINGE | NTS |
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D3813-3 HINGE, LOWER DOOR

